

Work Order ID 58368

Tuesday, May 04, 2010 1:57:11 PM



SHIP
MONDAY, May 10
Page 1

Item ID: D3861-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/4/2010

Start Qty: 5.00



Cust Item ID:

Required Date: 5/10/2010

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



FLOW WATER JET

0.00

R10-5-5

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3861 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(7)

110



QC2- Inspect parts off machine FAI/FAIB

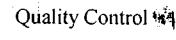
0.00

R10-5-5

QC

Memo

0.00



Quality Control

120



QC8- Inspect parts - second check

0.00

5/05/05

QC

Memo

0.00

(6)

Pn →

WO: 58368

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/15/05	# 120	Took off +1 for a c - inspection template	S	10/15/05	1		S 10/15/05

Part No: D3861-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58368

Tuesday, May 04, 2010 1:57:11 PM



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Item ID: D3861-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Large Fab

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3861 A/R 316L stainless steel rod
 Batch: M102421 2-Weld hard facing as per Dwg D3861 A/R
 2059B Hard Coat rod Batch: M114460 *****use
 DT9463 for welding*****

140



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control



150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID 58368

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Item ID: D3861-041

Accept



Setup

Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberReject
NumberInsp.
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

0.00

(6) 6R10-57.

180



Packaging

Packaging

Identify as per dwg & Stock Location: 508

0.00

0.00

0.00

10-5-1 SJ (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58368

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Item ID: D3861-041

Revision ID:

Item Name: Wearplate

Start Date: 5/4/2010 Start Qty: 8.00

Accept



Setup Start



Stop



Required Date: 5/10/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/05/07 JF

Memo

0.00

MF
10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 04, 2010 1:57:11 PM

Page 1

Work Order ID: 58368



Parent Item: D3861-041



Parent Item Name: Wearplate

Start Date: 5/4/2010

Required Date: 5/10/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

M304S16GA



Purchased

No

100

sf

110.5848

1.09

7.63



304/316 Sheet .063

D3009-3



Cup

Manufactured

No

130

Each

365.0000

6

14:167



Location

Loc Qty

Loc Code

MAT

110.5848

111323

0

114467

110.5848

(7)

Location

Loc Qty

Loc Code

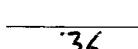
WA

365

42377

365

36



PL 10-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58368
Description: WEAR PLATE	Part Number:	D3861-1
Inspection Dwg:D3861-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

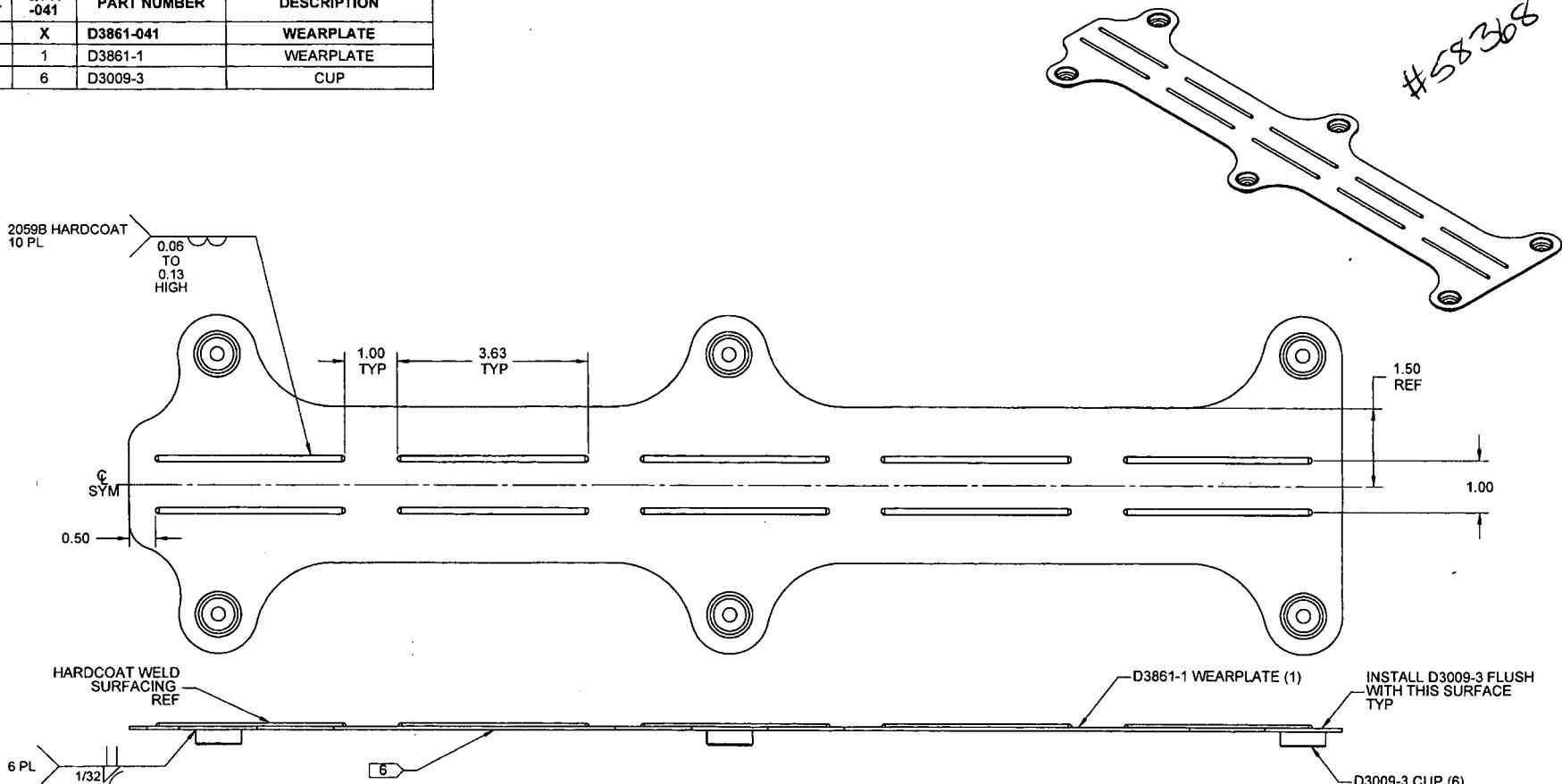
Measured by:	IB
Date:	10-5-4

Audited by:	S
Date:	10/05/05

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3861-041	WEARPLATE
2	1	D3861-1	WEARPLATE
3	6	D3009-3	CUP



D3861-041 WEARPLATE

NOTES

- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3861-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.69 lbs
 - 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION		BY DATE
DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>DS</i>	D3861	SHEET 1 OF 2
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	WEARPLATE	NTS
DATE	09.01.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

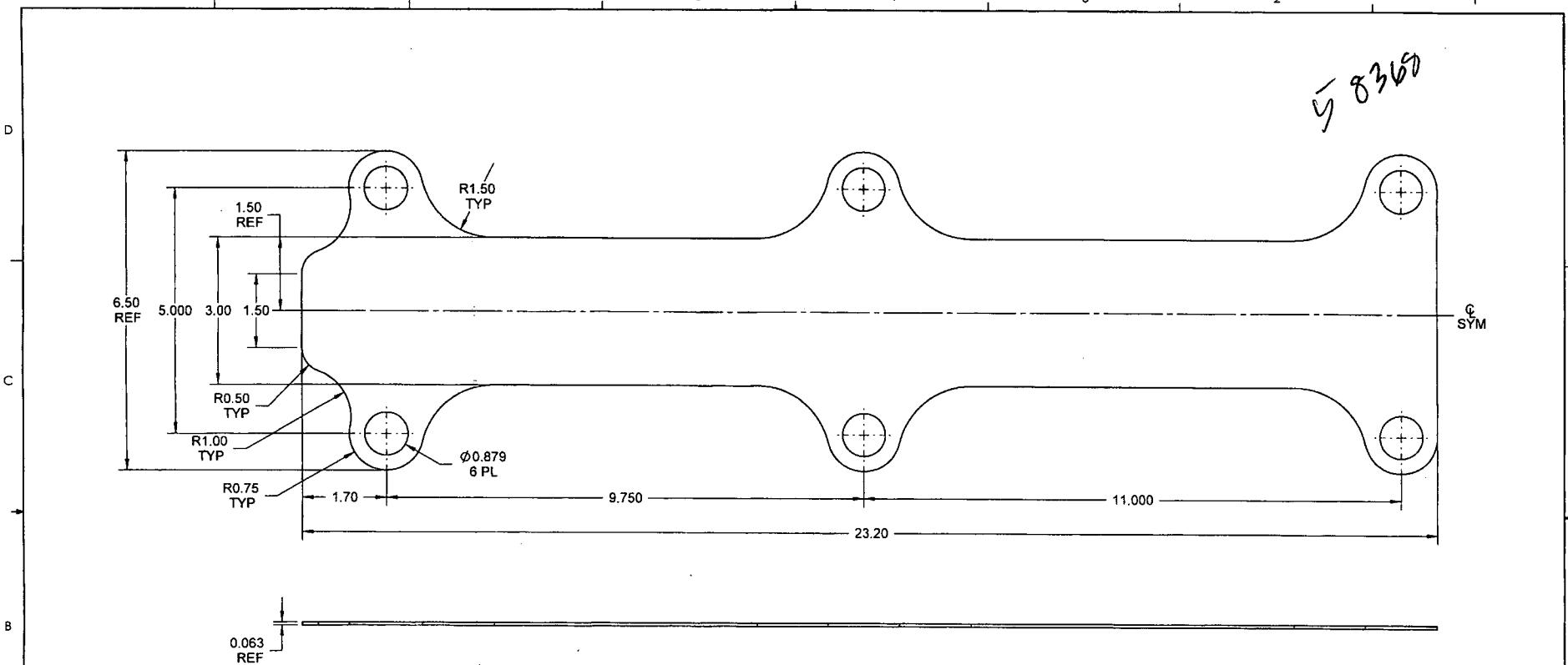
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3861-1 WEARPLATERELEASED
09.01.26

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.52 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>		
MFG. APPR.	<i>AS</i>	DRAWING NO.	REV. A
APPROVED	<i>AS</i>	D3861	SHEET 2 OF 2
DE APPR.	<i>AS</i>	TITLE	SCALE
DATE	09.01.26	WEARPLATE	NTS

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8 7 6 5 4 3 2 1

1

W/O:		WORK ORDER CHANGES					
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